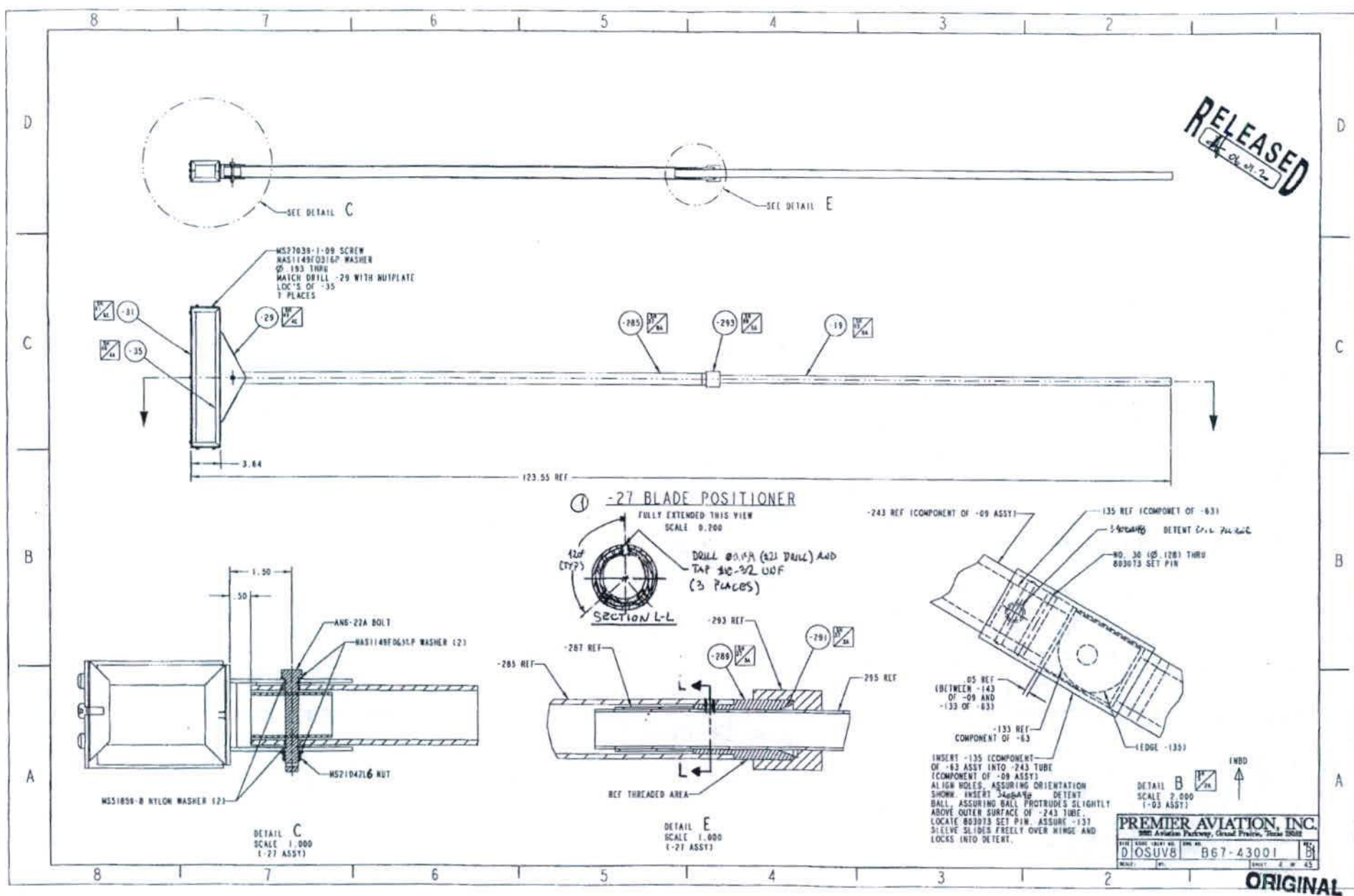








RELEASED  
44-287-72



REFERENCE ONLY

PREMIER AVIATION, INC.  
1000 Aviation Parkway, Grand Prairie, Texas 75050  
D10SUVB 867-43001

ORIGINAL









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# NOTES (UNLESS OTHERWISE SPECIFIED):

1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112. LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
3. GENERAL SHOP PRACTICES F.A.W. PREMIER SPEC. 000-93000 AND AC43.13.
4. OPEN
5. WELD PARTS PER MIL-2719, CLASS B.
6. CHEM FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 000-93003, CLASS 1A, AND PRIME WITH EPOXY PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-TTP-1757, OR EQUIVALENT.
7. STITCHING PER FED-STD-751.
  - WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (T-HANDLE LOCKED ON LOWEST HOOK), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RECESSED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE, .25 DIA.
  - INSTALL TEFロン TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 803073 SET PIN, AND GRIND FLUSH WITH COUOTUR OF OUTER TUBE. 8 PL 12 PL (A BUSHING)
  - GRIND BUSHING AND WELD TO COUOTUR OF TUBE.
  - ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING ON THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.
  - CHAMFER EDGE FOR BETTER WELDING.
  - TAP HOLE TO 1/4-20 THRU.
  - INSTALL CL-4P-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.
15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN640 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.
16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED, 234630 W OMSA YELLOW, PER FED-STD-525.
  - NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE, PER PREMIER SPEC 000-93003.
  - STITCH APPROX AS SHOWN, PER FED-STD-751.
  - PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THICKER NSS1858 EQUIVALENT.
  - DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADE/OLD ASSY TO AIRCRAFT.

- SECURE -43 BELT ASSY TO TOP OF -85 (OR -85) OR -47 (OF -01), LOCATE APPROX AS SHOWN.
- WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
- DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- SHIM AS REQD. USING NAS1149D0332J WASHERS.
- 01 TWO BLADE/OLD ASSY FOR COMMERCIAL VERSIONS ONLY  
-02 TWO BLADE/OLD ASSY FOR CANADIAN VERSIONS ONLY
- 26. TOLERANCE ON DECIMAL .X ± .1
- 27. LAST SECTION LETTER USED 'L'
- DRILL NO. 30 (60.126) HOLE THRU -37 AND AND -25 (COMPONENT OF -09 ASSY), INSERT 803073 SET PIN, AND GRIND FLUSH WITH -37.

REFERENCE ONLY

REV	DESCRIPTION	DATE	APPROVED
1	MFG. RELEASE	10/12/95	NH
2	CHANGES TO IMPROVE FUNCTIONALITY	12/1/96	NH
3	ONE AND P/L REVISED AND UPDATED TO REFLECT BELL MODIFICATIONS	01/15/98	NH
4	CHANGED DRAWING AFTER KIT	03/05/98	NH

REVISION: TEST C100 TP-042 605-11

RELEASED  
06-01-20

ECO  
5007  
5161  
6262

SEE SEPARATE PARTS LIST B67-43001PL

MATERIAL: DECIMALS: ANGLES: TOLERANCES: USED: REVISION:		DRAWN BY: CHECKED BY: APPROVED BY: RELEASED BY:		DATE: DATE: DATE: DATE:	
PRELIMINARY: TYPICAL:		PRELIMINARY: TYPICAL:		PREMIER AVIATION, INC. 900 Aviation Parkway, Grand Prairie, Texas 75050 BLADE FOLD KIT D. OSUV8 B67-43001	

ORIGINAL





Date: Thursday, 25/09/2008 10:50:57 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M107045

*M.F.*  
*Pl 08-10-24*

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/24 x2*

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B41181

*B41181*

*B41181*

*Lo*

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*2*  
*12/08/10/24*

Job Completion



*△ Add - PB6743001-305 x2 B 40063*

*MF 08-10-24*



Date: Thursday, 25/09/2008 10:50:57 AM  
User: \* Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

41.0	CR3213405	cherry rivet
------	-----------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
cherry rivet  
batch: m104214

mf 08-10-24

42.0	MS17984C413	PIN, QUICK RELEASE
------	-------------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
PIN, QUICK RELEASE  
batch: m18119 x 3, m108986 x 1

mf 08-10-24

43.0	MS17984C418	PIN, QUICK RELEASE
------	-------------	--------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)  
PIN, QUICK RELEASE  
batch: m108986

mf 08-10-24

44.0	30345T21	LANYARD
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
LANYARD  
batch: m107827

mf 08-10-24

45.0	30345T24	LANYARDS
------	----------	----------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)  
LANYARDS  
batch: m108390 x 9, m108973 x 3

mf 08-10-24

46.0	240107	SPRING SLOTTED PIN
------	--------	--------------------



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)  
SPRING SLOTTED PIN  
batch: m102940 x 30, m17850 x 6

mf 08-10-24

47.0	3408A98	DETENT BALL SPRING PLUNG
------	---------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
DETENT BALL SPRING PLUNG  
batch: m102312 x 3, m17828 x 1

mf 08-10-24





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m105442 x 5, m101291 x 1, m107178 x 2, MF 08-10-24

35.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m109282

MF 08-10-24

36.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: m19278

MF 08-10-24

37.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m105558

MF 08-10-24

38.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m104547

MF 08-10-24

39.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m108986 x 2, m18180 x 6

MF 08-10-24

40.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIVET

batch: m109119

MF 08-10-24



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m108986.

mf 08-10-24

28.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060

mf 08-10-24

29.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m108473

X

mf 08-10-24

30.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

batch: m18057

mf 08-10-24

31.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m18057

mf 08-10-24

32.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

mf 08-10-24

33.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 6085

mf 08-10-24





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Swing Arm

batch: 841352

MF 08-10-24

21.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: m17850

MF 08-10-24

22.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: m108057

MF 08-10-24

23.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: m18057

MF 08-10-24

24.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s)

Nut

batch: m104683x10, m107499x19, m108552x15, m105054x8

MF 08-10-24

25.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: m108183x5, m105077x11

MF 08-10-24

26.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m17890x4, m108986x20, m108473x8

MF 08-10-24



Date: Thursday, 25/09/2008 10:50:56 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bushing

batch: B41373

MF 08-09-25

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

batch: B40062

MF 08-09-25

15.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B41005~~ X2mx B41354 X2

MF 08-09-25

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B410124~~ X2mx X41353

MF - 08-09-25

17.0

D34401

Tube Guide (Supersedes B67-43001-25/307)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Tube Guide

batch: B41347

MF 08-09-25

18.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

batch: B41277

MF 08-10-24

19.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Velcro Loop Belt

batch: B39965

MF 08-10-24





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

PB67-43001-37

batch: 41379

mf 08-10-21

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Stabilizer Arm

batch: B41014 x 2

mf 08-10-21

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

PB67-43001-59

batch: B406 x 1, 3 x

mf 08-10-21

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle Assembly

batch: 41384

mf 08-10-21

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Male Eye

batch: B23945A

mf 08-09-25

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pin

batch: B41906 x 4

mf 08-09-25

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Lever Arm

batch: B41294 x 4

mf 08-10-21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Date: Thursday, 25/09/2008 10:50:56 AM  
 User: Melanie Fauleux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BLADE FOLD ASSEMBLY
Job Number : 41291 -2	
Estimate Number : 13532	
P.O. Number :	Part Number : PB674300103
This Issue : 25/09/2008 S.O. No. :	Drawing Number : B6743001 P.1,3,4,15
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/08/2008 Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 41239	Material :
Written By :	Due Date : 15/09/2008 Qty: 4 U:n: Each
Checked & Approved By : <u>mf 08-09-25</u>	
Comment : Est Rev:A 08-07-30 new issue DD verified by:ec	

Additional Product MS246945102 → M14604 QTY8 (FOR D3440-1)  
AN6C16A BOLT → M105831 → 8Qty

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB674300109

Aft Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Aft Blade Fold Assembly Weldment  
 batch: 41363

mf 08-10-24

2.0

PB674300113

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Aft Adjustable Blade Support Assembly  
 batch: 41366

mf 08-10-24

3.0

PB674300117

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Aft Adjustable Blade Support Assembly  
 batch: 41368

mf 08-10-24

4.0

PB674300121

PB67-43001-21



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 PB67-43001-21  
 batch: 41370

mf 08-10-24

5.0

PB674300123

PB67-43001-23



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 PB67-43001-23  
 batch: 41371

mf 08-10-24